

Date: Monday, 07/07/2008 4:23:02 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MOUNTING LUG
Job Number :	40341		
Estimate Number :	10256		
P.O. Number :		Part Number :	D22303
This Issue :	07/07/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2230 REV F
First Issue :	/ /	Project Number :	N/A
Previous Run :	39404	Drawing Revision :	F
	Type :	Material :	
	MACHINED PARTS	Due Date :	30/07/2008
Written By :		Qty:	200 Um: Each
Checked & Approved By :	<u>JUL 08 1.07</u>		
Comment :	Est D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.0717 f(s)/Unit Total: 14.3430 f(s)

Lug Extrusion

D2423

Batch: B33310

CL

2.0	BAND SAW	BAND SAW
-----	----------	----------



cut at Metec

Comment: Band Saw

Cut D2423 extrusion to 0.82"

Batch: _____

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Issue P.O. 6711

CL 08/07/08

(200)

Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio D2230-3

Check for crack while loading into the machine.

Machine per drawing D2230 Rev F

4.0	QC8	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Receive + inspect for transport damage

08/08/06

(200)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Ensure C/C attached

5.0	QC5	SECOND CHECK
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counters

Comment: SECOND CHECK

inspect level 5

08/08/11

(200)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 07/07/2008 4:23:02 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 40341

Part Number: D22303

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

Handwritten: n/a 8/8/14

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Handwritten: R/A 08/08/12 (200X)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 8 08/08/12 (200)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Handwritten: 9:00
320
9:30

Handwritten: m-l 08/08/13

Handwritten: (200X)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/INSPECT POWDER COAT

Handwritten: 08-08-13 (200)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Handwritten: ST 476

Handwritten: AS 08/08/13 (200)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 08/08/13

Job Completion



Handwritten: MF 08-08-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

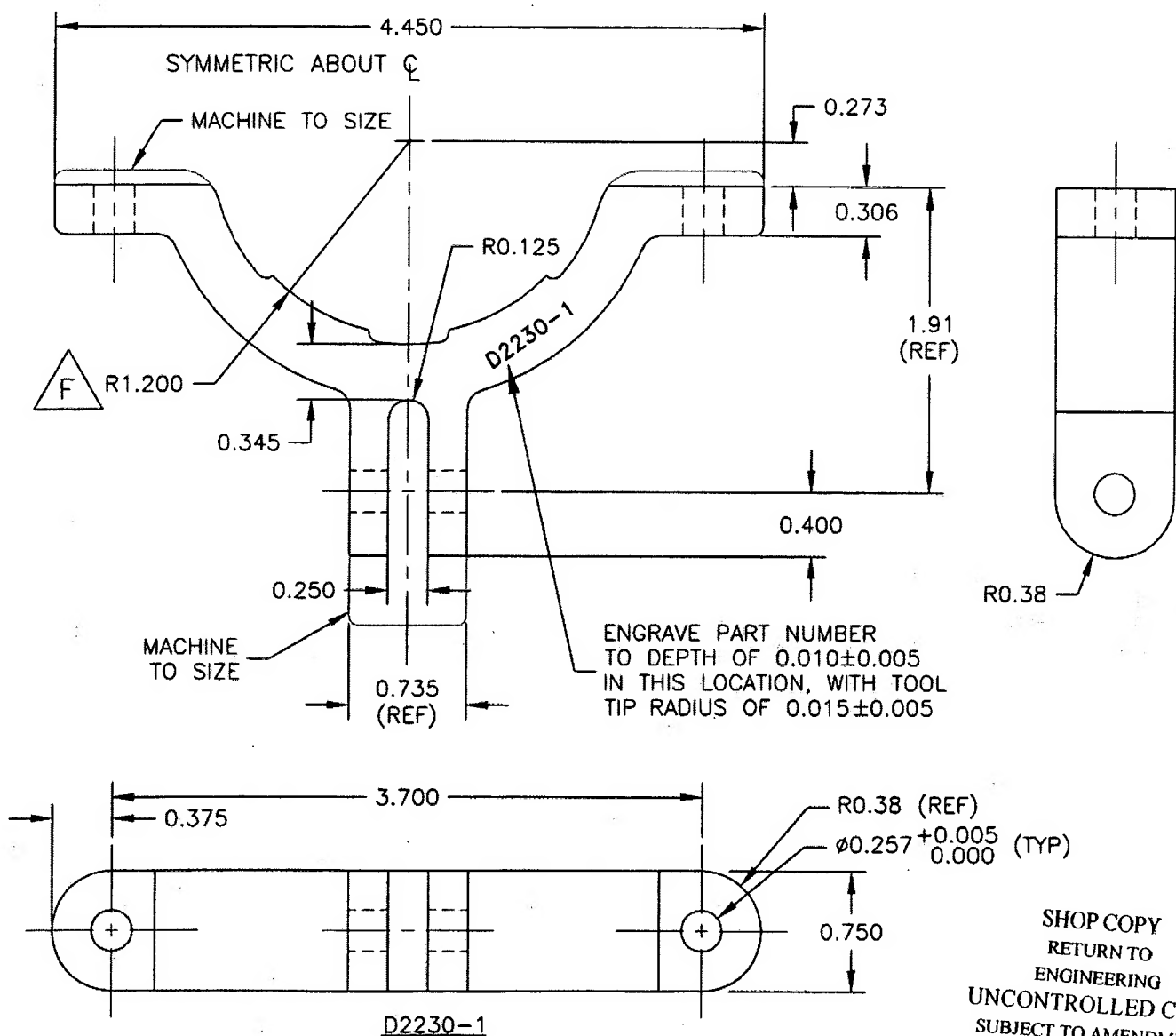
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. F
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2230	SHEET 1 OF 2
DATE	99.12.13	TITLE	MOUNTING LUG	SCALE	1:1
C	94.03.30	RE-DESIGN			
D	95.01.04	RE-DESIGN			
E	95.01.04	RE-DESIGN			
F	99.12.13	REDESIGN; R1.200 WAS R1.100			

RELEASED
199.12.21 DS

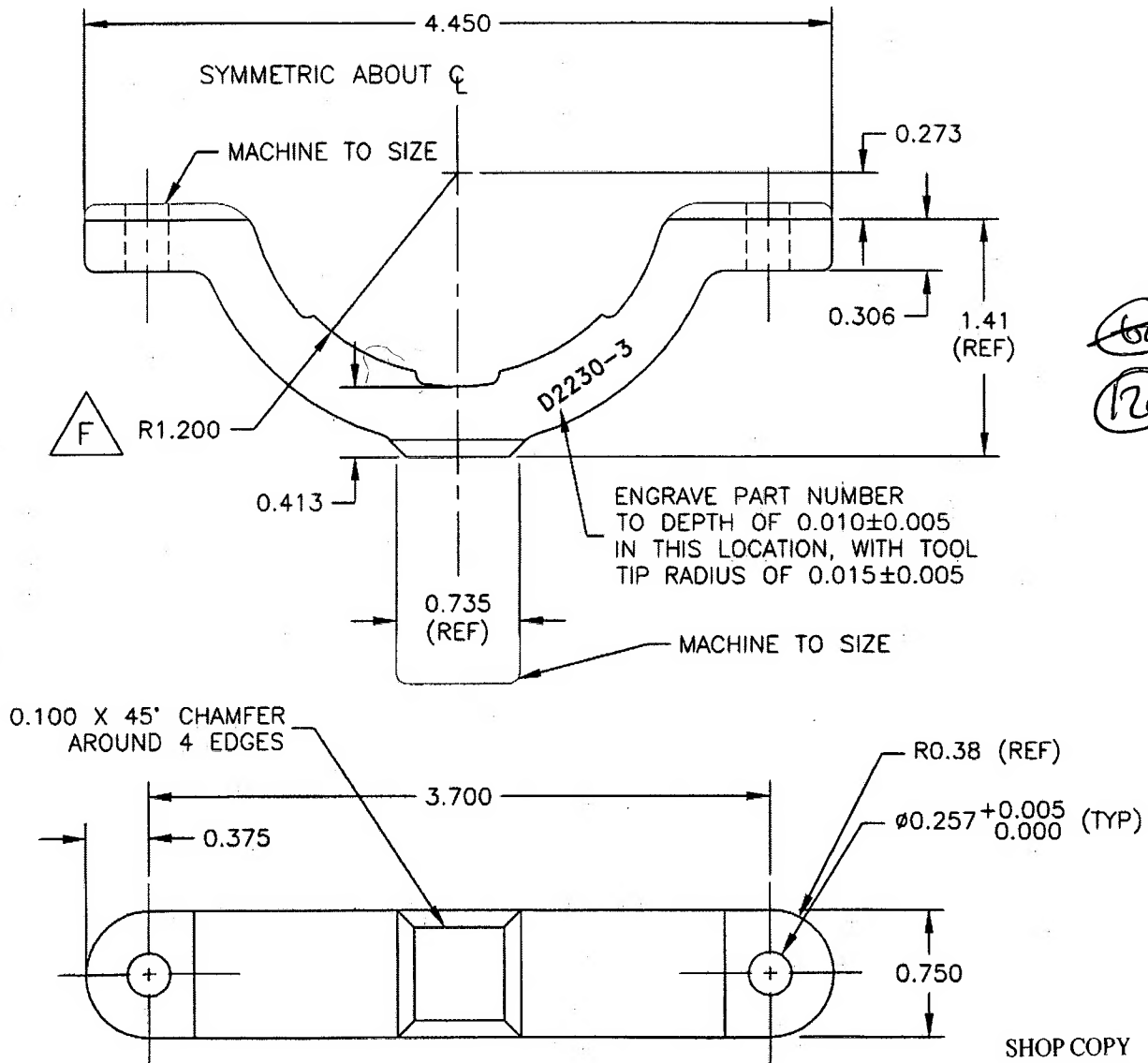


MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40341

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
49.12.21 DS

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40341



ORDER CONFIRMATION

Order No.: 6711
Date: Jul 10, 2008
Page: 1
Ship Date: Jul 25, 2008

Sold To:

Dart Aerospace Ltd.
Att. Linda Lacelle
1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7

Ship To:

Dart Aerospace Ltd.
Att. Linda Lacelle
1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7

Business No.: 867 061 723

Ordered	Unit	Description	Unit Price	Amount
200	Each	D2230-3 Mounting Lug Terms: 2%/10, Net 30 Delivery: As above Shipped By our truck	10.40	2,080.00
Thank you for your order!			Freight	0.00
			GST 6 %	104.00
			Total Amount	2,184.00

P.O. Box 781
Tel. 613) 678-3957 & 678-2782

20 Terry Fox Drive
Fax (613) 678-3956

Vankleek Hill, Ontario, K0B 1R0
metec@metec.ca / www.metec.ca



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

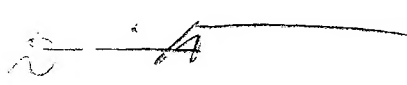
SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
200	D2230-3	Mounting Lug	6711
	MATERIAL: supplied by DART D2423 B33310		

We hereby certify that the above parts were made in conformance with applicable drawings. *S. 8/1/08*

METEC Metal Technology Inc.


Denise Fobinson

Vankleek Hill, August 1, 2008